Friday, 09/05/2008 1:45:22 PM

Julie Lecocq User

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 39152B

Estimate Number

: 10729

P.O. Number

This Issue

: 09/05/2008

: NC

Prsht Rev. First Issue **Previous Run**

: 11 : 37631

: SMALL /MED FAB Type

Part Number

Drawing Name

Drawing Number

: D23245 : D2324 REV C

: STRAP

Project Number

: N/A : C

Drawing Revision Material

Due Date

: 05/06/2008

Qty:

40 Um:

Each

Checked & Approved By

Comment

Written By

: Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5

J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

0.7360 sf(s)

0.0184 sf(s)/Unit 304/316 .063 Sheet

107676

Total:

304/316 .063 Sheet

2.0

WATER JET

Comment: Qty.:



Comment: FLOW WATER JET

1-Cut as per Dwg D2324

Dwg Rev: Prog Rev:

E1-2-12

2-Deburr if necessary

3.0



B 8-5-12



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



PACKAGING 1

PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospace Ltd

W/O:	W/O: WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						i i	
····		·				ļ	
						İ	
						1	
						,	

Part No: _	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
			QA: N/C	Closed:	Date: _	<u>.</u> .

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	A		
DATE	STEP	SIEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector		
							: 			
							l l			
							j			
							1			
							!			

NOTE: Date & initial all entries

Date: User: Friday, 09/05/2008 1:45:22 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 39152B

Part Number: D23245

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/15/1

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Le 8519

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						i	
						<u>'</u>	
						!	

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng			
				·			,			
							1	_		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39152B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

mapection bwg		ARTICLE IN	ISPECTION	ON CHE	CKLIST	•	ugo 1 01 1
	X	First Artic	_	-	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of	Co	omments
Dimension		Dimension			Inspection		
R0.38	+/-0.030	R 38	يو				
Ø0.257	+0.006/-0.001	1928	*	<u> </u>			
Ø0.191	+0.005/-0.001	.194	×				
0.750	+/-0.010	,748	X				
0.375	+/-0.010	375	×				
1.875	+/-0.010	1,875	×				
3.000	+/-0.010	3 200	X				
3.375	+/-0.010	3.376	XE.				
							A CONTRACTOR OF THE CONTRACTOR
٠.							
							···
							"
	-						· · · · · · · · · · · · · · · · · · ·
			-				
· ·			-				
		-		, ,			
					 		
	-				1		•
	·				<u></u>		
Measured by:	B	Audited by:	\rightarrow \(\text{\(\ext{\) \}}}}}} \end{\(\text{\text{\(\text{\(\text{\(\text{\) \}}}}} \end{\(\text{\\ \ext{\) \}}}} \end{\(\text{\(\text{\(\text{\(\text{\(\text{\(\text{\(\text{\(\text{\(\ext{\(\text{\) \}}}}} \end{\(\text{\) \end{\(\text{\(\text{\(\text{\(\text{\) \ext{\(\text{\(\text{\) \ext{\(\text{\(\text{\(\text{\) \ext{\(\text{\) \ext{\(\text{\(\text{\) \ext{\(\text{\(\text{\) \ext{\(\text{\)}}}}} \ext{\(\text{\\ \ext{\) \ext{\} \ext{\(\text{\} \ext{\ \ext{\} \ext{\ \exi}}}}} \ext{\ \ext{\ \ext{\ \ext{\ \exi{\ \ext{\ \ext{\ \exi{\ \ext{\ \exi}}}}} \exi{\ \exi{\ \exi}}}} \exi{\ini}}}		Prototype App	roval:	N/A
Date:	8-5-13	Date:	08/05	1/2		Date:	N/A
			0000				

Rev	Date	Change	Rev		Approx/ed
Α	06.06.05	New Issue	KJ/J	LM ox	\(\mathbb{I}\) \(\mathbb{I}\)



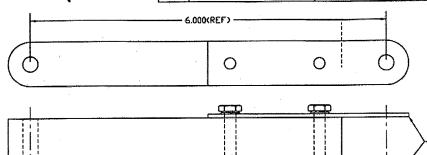
DRAWN BY DESIGN DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** PH REV. C DRAWING NO. CHECKED ! APPROVED D2324 SHEET 1 OF 1 DATE TITLE SCALE **STRUT** 04,12,14 NEW ISSUE Α 94.11.08 96.05.07 UPDATE MATERIALS В C UPDATE NOTES 04.12.14

D2324-5

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1)

(TWO PLACES)

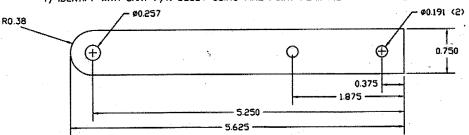
04.12.16 -



D2324 STRUT ASSEMBLY

D2324-3

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

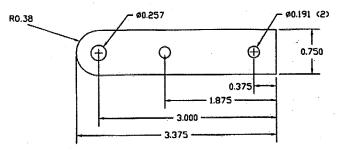
1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T6B0.750X00.750)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



02324-5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)

(REF DART SPEC. M304S16GA)
) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Dart Aerospace Ltd

W/O:		WORK ORDER CHAP	WORK ORDER CHANGES				
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:	
							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
			QA: N/C	Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section 6	3	Verification	Approval	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng			
		•	·				1			
							; ! !			
							!			

NOTE: Date & initial all entries